



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2053

Job Sheet 168309



Part No: D2053

Job Qty: 10 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/13/17

Job Tracking No:

Due Date: 11/21/17

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV C IPP D 02.03.18 Added Rev.B NG (Issue this IPP with part number D2052) IPP Rev:E now water jet 07-10-25 DD IPP Rev:F 08-05-14 chg to revC as per ECN1171 DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		11/20/17	0.00	0.00	Start Up Waterjet		on 17/12/28
100	Waterjet	10 pcs		11/20/17	0.00	0.31	Waterjet1		on 17/12/28
110	QC	10 pcs		11/20/17	0.00	0.00	QC2		on 17/12/28
120	QC	10 pcs		11/20/17	0.00	0.00	QC8		38
130	Brake NC	10 pcs		11/20/17	0.00	0.18	Brake NC 2		9-89 SD
140	QC	10 pcs		11/20/17	0.00	0.00	QC5		23
150	HandFinish	10 pcs		11/20/17	0.00	0.15	HandFinish1		18-02-06
160	Powdercoat	10 pcs		11/21/17	0.00	0.12	Powdercoat4		BR 18-2-7
170	QC	10 pcs		11/21/17	0.00	0.00	QC3		38
180	Packaging	10 pcs		11/21/17	0.00	0.00	Packaging3	stock	0-08 21 9-08 SCL
190	QC21-SA	10 Ea		11/21/17	0.00	0.00	QC21		0-00 FEB 1 2 2018

Part Op **100** - 1-Cut as per Dwg D2053 Dwg Rev: C Prog Rev: C ****grain direction along 1.987" **** 2-Deburr if
Descriptions: necessary

110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - Form as per Dwg D2053 using CNC Brake

140 - QC5- Inspect part completeness to step on W/O

150 - Chemical Conversion Coat per QSI005 4.1

160 - START TIME: 9:20 OVEN TEMPERATURE: 320° FINISH TIME: 9:50

170 - QC3- Inspect Part Finish

180 - Identify as per dwg & Stock Location:

190 - QC21- Final Inspection - Work Order Release

Job Allocations

M5052H32S.096

Job Allocations could not be found.

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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QA Closed: _____ Date: _____

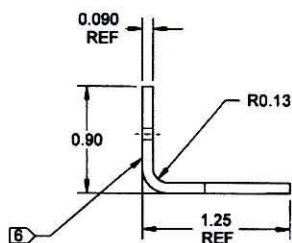
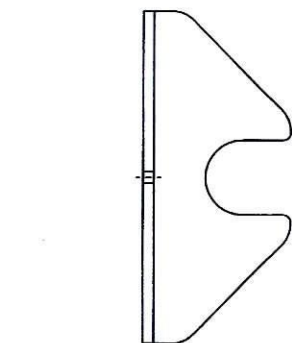
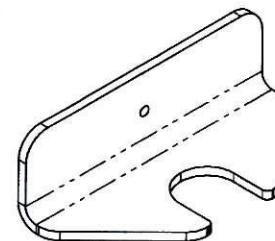
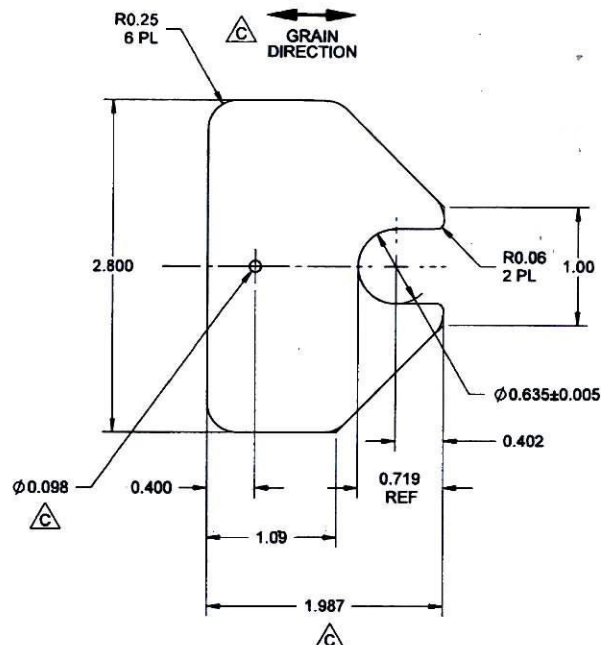
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NOV 16 2017

DAS-30-9-86

NO. 168309
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

**D2053 BRACKET****D2053F FLAT PATTERN****RELEASED**
08.05.13.11**NOTES:**

1) MATERIAL: 5052-H32 ALUMINUM SHEET 0.090 THICK PER QQ-A-250/8 OR AMS 4016
(REF DART SPEC M5052H32S.090)

OR

6061-T6 (OR -T62) ALUMINUM SHEET 0.090 THICK PER QQ-A-250/11 OR AMS 4025/4027
(REF DART SPEC M6061T6S.090)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2053" USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH

7) WEIGHT: 0.04 lbs

C	1.987 WAS 1.979 (ZN B5-1); ADD WEIGHT (ZN A8-1); ADD IDENTIFICATION (ZN A4-1); ADD Ø0.098 HOLE FOR POWDER COAT MOUNTING (ZN B6-1); ADD CHEMICAL CONVERSION COAT AND CHANGE TO BLACK SANDTEX (ZN A6-1); ADD 6061-T6 MATERIAL OPTION (ZN A5-1); ADD GRAIN DIRECTION (ZN D5-1); QTY (2) Ø0.213 MOUNTING HOLES REMOVED; REASON: PRODUCT IMPROVEMENT	PH	08.04.25
B	Ø0.635 WAS Ø0.437; 0.635 WAS 0.325	DS	02.03.12
A	NEW ISSUE	DS	92.01.12
REV.	DESCRIPTION	BY	DATE
DESIGN	DA	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BA		
CHECKED	NP	DRAWING NO.	REV. C
MFG. APPR.	NP	D2053	SHEET 1 OF 1
APPROVED	NP	TITLE	SCALE
DE APPR.	NP	BRACKET	NTS
DATE	08.04.25	COPYRIGHT © 1992 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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